

Date: Thursday, 6/21/2007 2:28:37 PM  
User: Kim Johnston

# **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 33041		
Estimate Number	: 10531		
P.O. Number	: <u>N/A</u>	Part Number	: D2572
This Issue	: 6/21/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2572 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: E
Previous Run	: 32166	Material	: <u>N/A</u>
Written By	: _____	Due Date	: 7/11/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	12 Um: Each
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2572  
Ensure that grain is along 5.00" length  
Batch No: 25350

[Signature] 07/07/10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. SA Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove shap edges.

[Signature] SA 07.07.10

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2571 & D2572

[Signature] SA 07.07.10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] SA 07.07.10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/07/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:28:37 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 33041

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 07/07/13

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MA 07-07-16 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN SANDTEX (Ref: 4.3.5.1) as per QSI 005 4.3

M/BR 07-07-16 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/7/17 (12x) 50

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/7/17 50 (12x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.17

Job Completion



h 07/07/17

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>33041</b>
<b>Description: Saddle, Fwd Inboard</b>	<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg: D2572 Rev. E</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	0.440	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.749	1.749		
E	7.990	8.010		7.998	7.997	8.000	7.999		
F	0.490	0.510		0.500	0.507	0.502	0.503		
G	0.257	0.262	<del>DT8683</del>	0.258	0.258	0.258	0.258		
H	0.375	0.380	<del>DT8684</del>	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.504	0.497	0.498	0.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.569	0.567	0.567	0.569		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.494	1.494	1.494		
N	2.495	2.505		2.499	2.500	2.499	2.500		
O	3.869	3.879		3.872	3.871	3.872	3.872		
P	0.115	0.135		0.123	0.124	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.257	0.257	0.257		
S	0.115	0.135		0.135	0.131	0.132	0.132		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.961	2.961		
V	0.230	0.250		0.249	0.240	0.241	0.242		
W	0.115	0.135		0.130	0.132	0.131	0.130		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.358	0.362	0.360	0.363		
AA	0.470	0.530		0.506	0.500	0.500	0.500		
AB	0.615	0.635		0.636	0.630	0.630	0.636		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.257	0.248	0.247	0.248		
AE	1.375	1.395		1.383	1.386	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.262	0.260	0.260	0.260		
AH	0.240	0.260		0.257	0.257	0.252	0.253		
AI	2.000	2.020		2.000	2.002	2.004	2.003		
AJ	0.023	0.043		0.033	0.037	0.033	0.033		
Accept/Reject									

Measured by:	<i>Jul</i>
Date:	07/07/09

Audited by:	<i>J.L.</i>
Date:	07/07/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>Jul</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>33041</b>
<b>Description: Saddle, Fwd Inboard</b>	<b>Part Number:</b>	<b>D2572</b>
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B	1.745	1.755		1.749	1.749	1.750	1.749		
C	3.495	3.505		3.499	3.506	3.500	3.500		
D	1.745	1.755		1.749	1.749	1.749	1.750		
E	7.990	8.010		8.000	7.998	8.001	8.002		
F	0.490	0.510		0.501	0.500	0.499	0.493		
G	0.257	0.262	<del>DT8683</del>	0.258	0.258	0.258	0.258		
H	0.375	0.380	<del>DT8684</del>	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.506	0.506	0.498	0.500		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.567	0.568	0.566	0.568		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.494	1.494	1.494		
N	2.495	2.505		2.506	2.506	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.871		
P	0.115	0.135		0.124	0.124	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.256	0.251	0.251		
S	0.115	0.135		0.136	0.132	0.132	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.966	2.961	2.961	2.961		
V	0.230	0.250		0.240	0.241	0.241	0.241		
W	0.115	0.135		0.126	0.130	0.130	0.129		
X	0.307	0.312		0.310	0.310	0.311	0.311		
Y	0.760	0.765		0.766	0.760	0.762	0.762		
Z	0.352	0.372		0.365	0.364	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.630	0.630	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.249	0.248	0.249		
AE	1.375	1.395		1.385	1.385	1.385	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.266	0.266	0.266	0.260		
AH	0.240	0.260		0.249	0.251	0.251	0.251		
AI	2.000	2.020		2.001	2.003	2.002	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>ML/SA</i>
Date:	<i>07/07/13</i>

Audited by:	<i>J.L</i>
Date:	<i>07/07/13</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>SA</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	33041
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
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D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.001	7.999	8.007		
F	0.490	0.510		.502	.500	.498	.495		
G	0.257	0.262	<del>DT8683</del>	.258	.258	.258	.258		
H	0.375	0.380	<del>DT8684</del>	.376	.376	.376	.376		
I	0.490	0.510		.502	.503	.500	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.565	.570	.571		
L	1.174	1.184		1.179	1.179	1.177	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.499	2.499	2.498		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.124	.124	.124	.124		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.251	.251	.252	.251		
S	0.115	0.135		.130	.131	.131	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.962	2.961		
V	0.230	0.250		.242	.243	.241	.243		
W	0.115	0.135		.125	.125	.129	.125		
X	0.307	0.312		.311	.310	.311	.311		
Y	0.760	0.765		.762	.762	.762	.762		
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AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.257	.252	.257	.257		
AE	1.375	1.395		1.386	1.385	1.386	1.386		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.252	.254	.251	.251		
AI	2.000	2.020		2.002	2.007	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SA
Date:	07/07/10

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D	05.05.05	Added dimension AI	KJ/RF	
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05.12.06

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